

DART AEROSPACE LTD		Work Order:	22936
Description: Pedal Lock Base		Part Number:	D3368-1
Dwg: D3368 Rev. A		Qty:	4
Page 1 of 1			

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	PA	05.04.07	4
2	MV	Cut blank: 2.00" x 2.00" x 10.450" long Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B2.000x02.000) Identify for D3368-1 Batch: M1712-1	EL	05/04/12	4
3	MV	Machine D3368-1 as per Folio FA499 and Dwg D3368 Identify as D3368-1	BL	05/04/13	4
4	QC2	Inspect parts as they come off the CNC machine	BL	05/04/13	4
5	QC8	Second check	EP	05/04/13	4
6	MV	Deburr	BL	05/04/13	4
7	QC5	Inspect work to Step 6	EP	05/04/13	4
8	FP	Chemical Conversion Coat as per QSI 005 4.1	ML	05.04.13	4
9	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3	ML	05.04.14	4
10	QC3	Inspect Powder Coat	2	05-04-15	4
11	ST	Identify and Stock	2	05-04-15	4
12	AC	Cost / part 60.84	5AC	05.04.19	4
13	DC	Close W/O 48.43 Inspect Level 21	PA	05.04.20	4

Rev	Date	Change	Revised By	Approved
A	05.01.27	New issue	KJ/JLM	

RELEASED
05-01-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/04/13	3	Drilled hole x2 too deep Hole position changed for new hinge (1) BASE (1) COVER	<i>[Signature]</i> 05.04.13	Weld + grind for cosmetic DRAWING D3368 HAD BEEN MODIFY TO CORRECT THE PROBLEM. SEE DWG. <i>[Signature]</i> 05.04.13 D3368 REV. B	<i>[Signature]</i> 05.04.13	<i>[Signature]</i> 05.04.13	<i>[Signature]</i> 05.04.13	<i>[Signature]</i> 05.04.13

Part No: D3368-1 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *[Signature]* Date: 05/04/20
 NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3368	REV. A SHEET 1 OF 3
DATE 05.01.19		TITLE PEDAL LOCK	SCALE 1:3
A	05.01.19	NEW ISSUE	

RELEASED
[Signature]

05/02/22

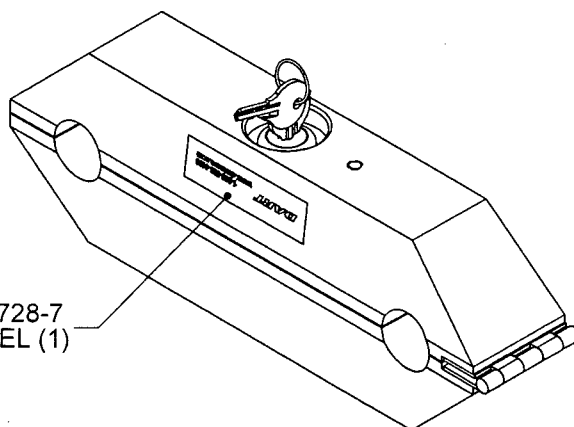
CANCEL ~~RF~~ 05.04.09

UNDER REVIEW

~~RF~~ 05.03.22

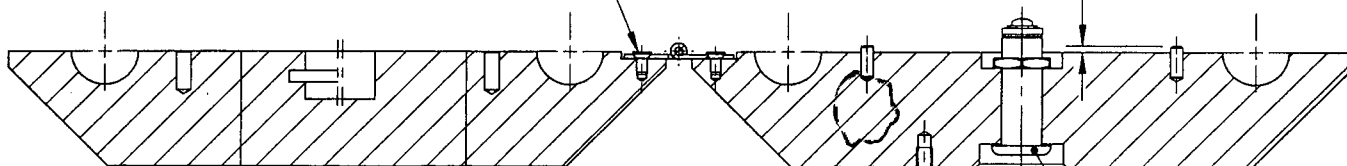
WEIGHT REDUCTION
+ HINGE CHANGE

D2728-7
LABEL (1)



PEDAL LOCK SHOWN LOCKED WITH KEY

1 MACHINE SCREW #8-32 x 0.313 LONG
(4 PLACES)



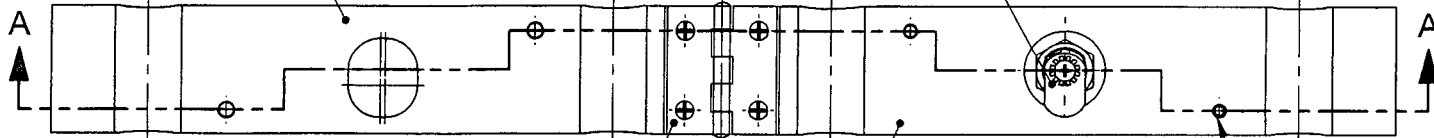
SECTION A-A

0.100
(2 PLACES)

D3373-7 CAM
LOCK ASS'Y

D3368-1 BASE (1)

D3371-5 CAM (1),
SQUARE WASHER SPACER (1),
EXTERNAL TOOTH LOCK WASHER (1),
#10-32 UNF PAN CROSS HEAD SCREW (1),
(AS PER D3373-1)



D3385-1 HINGE (1)

D3368-3 COVER (1)

STD. GROUND DOWEL
PIN $\varnothing 3/16$ x 0.50 LONG
(2 PLACES)

D3368-051 PEDAL LOCK ASSEMBLY

NOTES:

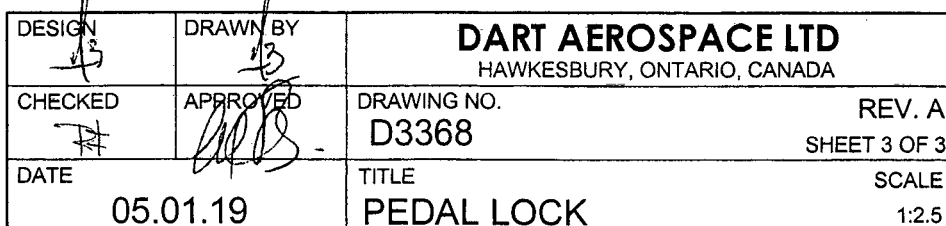
- 1) POSSIBLE SUPPLIER: SPAENAU P/N 385-039
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

LONG COPY
RETURN TO
ENGINEERING
UNREVIEWED COPY
FOR COMMENT
FOR PRACTICE

W/ ORDER
NO. 22936

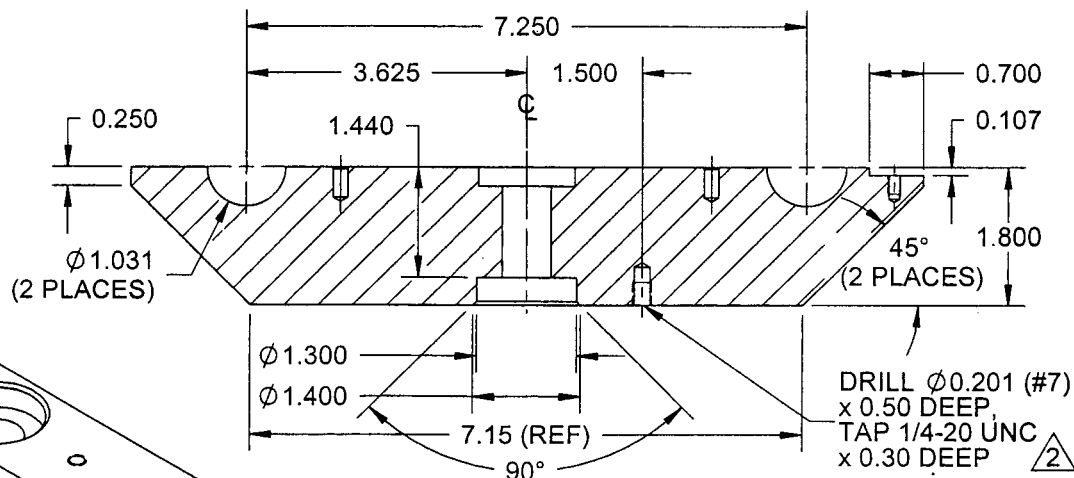
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05/02/22

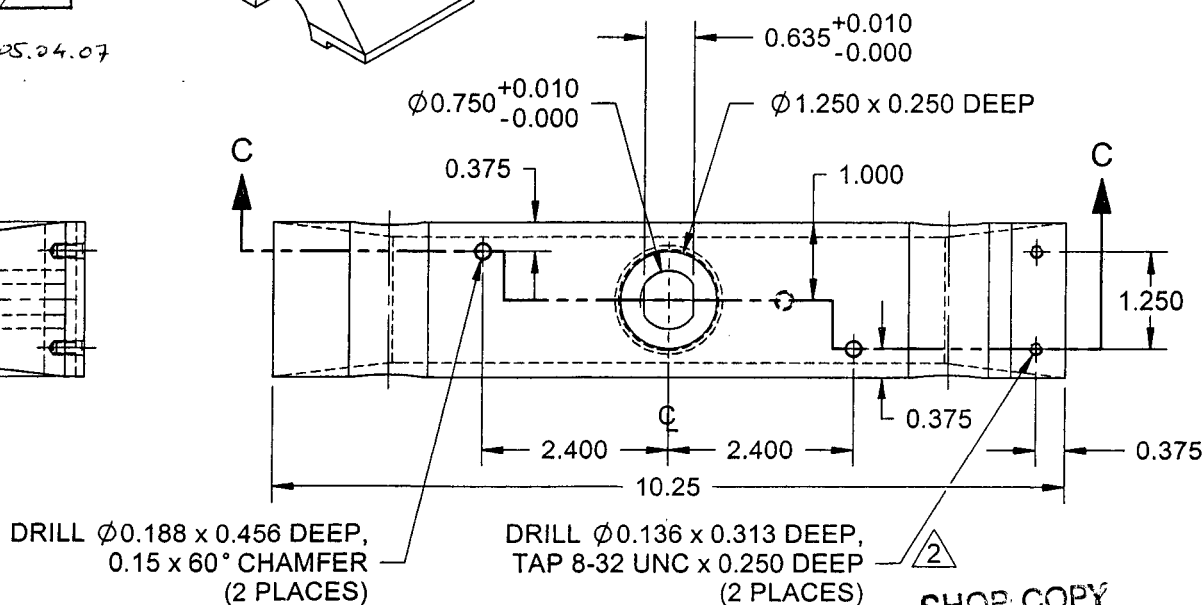
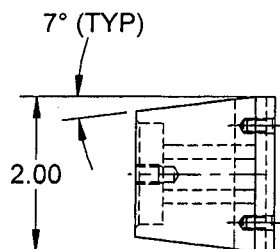


SECTION C-C

~~UNDER REVIEW~~

~~08.03.22~~

CANCEL ~~TR~~ 05.04.07



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UNCONFIDENTIAL COPY
SUBJECT: [REDACTED]
[REDACTED]

WORK ORDER

ED NO. 22936

D3368-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) SU
(REF. DART SPEC. M6061T6B)
2) COVER INSIDE HOLES PRIOR PAINTING
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 W
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES IN
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 07, 2005
10:55 am

Work Order No : 0022936
Project Name : D3368-1
Project For : WK515
Work Order Type : Main
Main WO Number :
House Part Number : D3368-1
Description : Pedal Lock Base
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 04-07-05
Est Finish Date : 04-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD

Work Order: 22936

Description: Pedal Lock Base

Part Number: 03368-1

Inspection Dwg: 03368 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.25	±.03	10.253	✓			
7.250	±.010	NA				No Holes
3.625	±.010	NA				
.188	±.010	.186	✓			
.485	±.010	.480	✓			
.750	±.010	.749	✓			
.250	±.010	.250	✓			
1.800	±.010	1.797	✓			
.107	±.010	.107	✓			
Changed 3.00 .650	±.010	.650	✓			Was .700 changed to .650 New hinge
2.00	±.03	1.990	✓			MAT. thickness/width
5.125	±.010	5.126	✓			
.375	±.010	.370	✓			
2.400 X 2	±.010					
.375 .275	±.010	.271	✓			Hole spacing change
Changed 1.450	±.010	1.450	✓			Was 1.250 changed to 1.450
310 .375 .375	±.010					Hole spacing changed
.375 .275	±.010					ii
1.075	±.010	1.076	✓			
1.250	±.010	1.250	✓			
φ.230 X .600 T	±.010	φ.230 X .600	✓			

Measured by: DG.

Audited by: Er

Prototype Approval:

Date: 05/04/12

Date: 05/04/13

Date:

Rev

Date

Change

Revised by

Approved

A

New Issue

KJ/JLM